

Work Order ID 86718

86718

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July-06-12 11:42:41 AM

Item ID: D2279 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 7/06/12 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-09-17 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2279	Rev D					(87)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D 2279 Dwg Rev: <u>0</u> Prog Rev: <u>0</u> 2-								
2024 . 046	Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

5mb
12.7.23

DAS
16

214/25

(27)

12-7-24

12-7-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>12/18/16</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00							<u>12/08/16</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>MLJ 12/08/16</u> <u>MLJ 12/08/16</u>

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Picklist Print

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Work Order ID: 86718

Parent Item: D2279

Parent Item Name: Step Spacer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev: A New Issue 05-11-07 JLM
IPP Rev: B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	178.1612	0.147	3.7136832	4,	1812-7-24	

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

27

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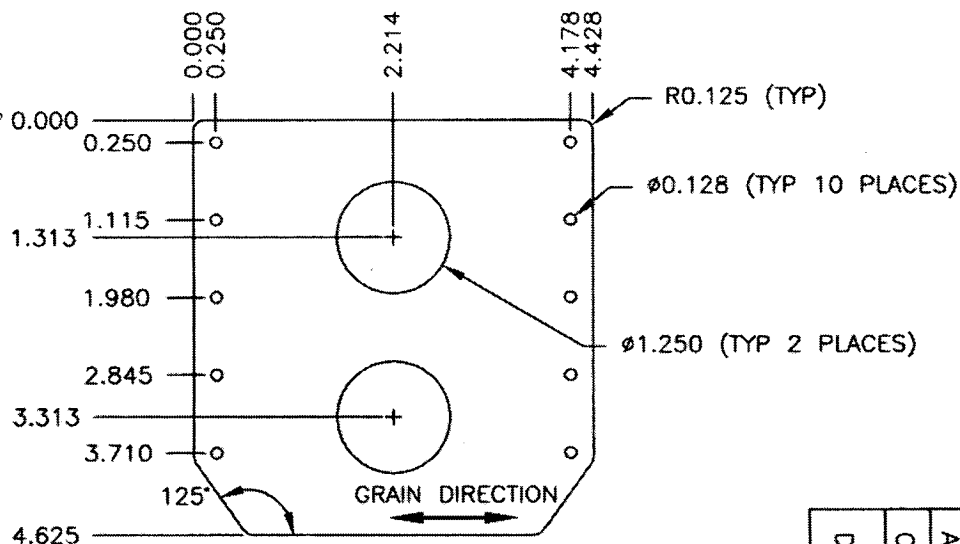
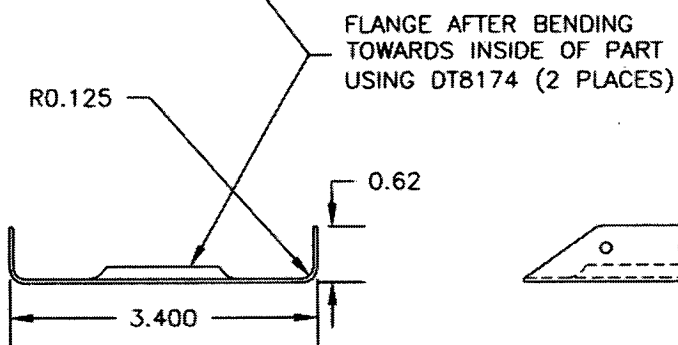
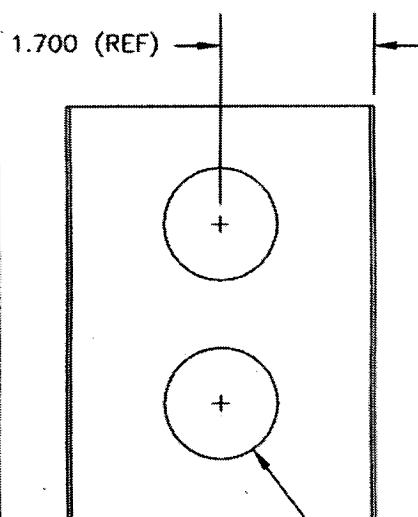
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NO. 86718

PL 07-9 0.000



FLAT LAYOUT

UNDER REVIEW

98.10.08 DS

~~DESIGN OK, BUT CHECK WITH
73 BEFORE MANUFACTURE~~

2000

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



DESIGN BIV	DRAWN BY CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED MH	DRAWING NO. D22279	REV. D SHEET 1 OF 1
DATE 98.10.05	TITLE STEP SPACER SCALE 1:2		
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	

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